

Work Order ID 86704

\*86704\*

Page 1

July-06-12 11:37:25 AM

Item ID: D206-642-241

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 7/06/12 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:  Date: 207-11 Tooling: Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2650	Rev F
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100: 0.00

\*100\*

DOCUMENT CONTROL

0.00

DC

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-241 CHG005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D206-642-241

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Replacement Skidtube

Start Date: 7/06/12 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00 \*1\*

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

\*110\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number DescriptionBatch

A/R Aluminum Rod M122324/M12230

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

> CF 12.7.26

BE 120726

SAP 120807

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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July-06-12 11:37:25 AM

Item ID: D206-642-241 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 7/06/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

SAD 12-08-07

120

**\*120\***

QC

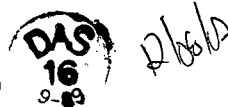
Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

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Start Date: 7/06/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open crossbolt holes to Ø0.3125"								
	2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.								
	3-Deburr tube and blow out chips from inside the tube								
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

1 SAP 12-08-07

1 76 12.88

① MD  
SAP 12-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*1\***

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
<b>*160*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								
170	QC6- Inspect dimensions to drawing	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

① S.A.D. 6/28-08

DAS  
16  
9-83 7/26/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

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Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 7/06/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

**\*180\***

Skidtubes

Skidtubes

Skidtubes

Memo

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12/08/15 Time: 4:00  
Finish Date: 12/08/21 Time: 8:00

Pick:

Qty Part Number Description Batch  
A/RSikaflex-291 141032013  
Sikaflex expire date: 7/12/2443

0.00

0.00

0.00

0.00

190

**\*190\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

① SAD 10-08-09

1 0 12/08/21 DAS  
18  
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Setup Start **\*NS1\***

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Item Name: Replacement Skidtube

Start Date: 7/06/12 Start Qty: 1.00 **\*1\***

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Required Date: 8/10/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00

**\*200\***

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch  
A/RAluminum Rod M122324

3-Grind welds flush as per Dwg D2650. SAD 12-08-22

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 12-08-22

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

*BE 12/08/21*

*DD 12-8-23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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 Required Date: 8/10/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
*210*	HandFinish	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D2650								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
*220*									
QC	Memo	0.00							
Quality Control									
230	QC5- Inspect part completeness to step on W/O	0.00							
*230*									
QC	Memo	0.00							
Quality Control									

DP 12-8-23

DAS 16 12/08/29

DAS 24 12-8-27

DAS 16 12/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D206-642-241 Accept \*N900040100\* Setup Start \*NS1\*  
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 Item Name: Replacement Skidtube  
 Start Date: 7/06/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pressure Wash per QSI005 4.3	0.00							
*240*									
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.								
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*250*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:00 OVEN TEMPERATURE: 320°F FINISH TIME: 12:30								
260	QC3- Inspect Part Finish	0.00							
*260*									
QC	Memo	0.00							
Quality Control									

1 76 12-8-27

1X 12/8/27

1 12/09/04

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00							
<b>*270*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/RSikaflex-291 <u>122443</u> Sikaflex expire date: <u>13/03</u>								
	2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.								
	3-Install MS27039-4-06 Screw as per DEO 9153.								
	4 -Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>122443</u> Sikaflex expire date: <u>13/03</u>								
	5 -Wing Walk as per Dwg D2650-3 and QSI 005 4.4 A/R Batch: <u>122326</u> <del>Batch</del>								
300	QC5- Inspect part completeness to step on W/O	0.00							
<b>*300*</b>									
QC	Memo	0.00							
Quality Control									

SWAB

12-9-5

DAS 16 8-03

17/09/05

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 7/06/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00

**\*1\***

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
310		0.00							
<b>*310*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-664-241								
	Location: _____								
	PPP Rev: _____								
320	QC21- Final Inspection - Work Order Release	0.00							
<b>*320*</b>									
QC	Memo	0.00							
Quality Control									

PP 87128

12/2/22 SD

MLJ 12/09/12

ME  
12-09-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 1

8

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD  
10.01.06 verified by: ECIPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620 Skidtube, 206 Skidtube		Manufactured	No			110	Each	31.0000	1	1		CF 12-1-26	

Location	Loc Qty	Loc Code
LG	31	
79543	2	
81365	1	
82517	3	
82518	5	
86331	20	

D3286-1  
Doubler

Manufactured No

110 Each 61.0000

2 347 12-07-08

Location	Loc Qty	Loc Code
LG002	173	
74872	6	
78014	6	
79556	43	
ST046	-112	
76772	6	

D2647  
Cap

Manufactured No

110 Each 65.0000

1 1 BE 12-07-26

Location	Loc Qty	Loc Code
LG002	65	
75482	3	
79563	62	

D2654-3  
Web

Manufactured No

180 Each 4.0000

1 1 SAP 12-08-09

Location	Loc Qty	Loc Code
LG	4	
85944	4	

B 86688 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 2

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

3,959.0000

52

Cherry Rivet

52  
SAD 1d-08-09

Location

Loc Qty

Loc Code

ST331

116

116471

36

117816

3

118686

1

118840

16

119017

60

st510

3843

119075

3843

52

D2649

Manufactured

No

200

Each

351.0000

18

18

Cross Bolt Spacer

BC-12-08-21

BB6912 x/8

Location

Loc Qty

Loc Code

LG

208

77574

2

79502

8

79503

5

79564

4

79565

7

85586

182

LG001

143

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

16

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

D3286-3 Spacer	Manufactured	No	200	Each	40.0000	2	2	<u>8-12/08/22</u>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			LG	38				
			81975	38		<u>2</u>		
			LG001	2				
			74117	1				
			79557	1				
D2680-041 Nut Plate	Manufactured	No	210	Each	74.0000	1	1	<u>DP 12-8-23</u>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST013	74		<u>①</u>		
			78016	74				
CR3212-4-03 Cherry Rivet	Purchased	No	210	Each	1,248.0000	2	2	<u>DP 12-8-23</u>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	340		<u>②</u>		
			114859	340				
			ST331	908				
			110139	2				
			119017	906				
CCR264SS3-3 Cherry Rivet	Purchased	No	210	Each	320.0000	2	2	<u>DP 12-8-23</u>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST331	320		<u>②</u>		
			113973	2				
			117849	77				
			119017	241				

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

D2646  
Aft Cap

Manufactured No

270 Each 81.0000

1 1 28 12/09/04

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002 85848 ✓	81	
62678	5	
68280	5	
70945	1	
71070	2	
73294	1	
73825	2	
79562	4	
81974	28	
85443	33	

D2651-1

Plug

Manufactured No

270 Each 474.0000

18 18 28 12/09/04

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	200	
FP001	425	
57869	1	
66445	10	
69018	2	
70827	2	
70839	8	
71037	8	
77559	30	
78584	18	
79234	46	
FP002	203	
85456 ✓	203	
FP-A	-354	
77559	1	
78124	5	
81954	36	
82573	104	

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 5

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

AN960JD416  
Washer

\* NAS1149D0463J ✓ Purchased No

270 Each 29.0000

1 1 12/09/04

Location

Loc Qty

Loc Code

ST351 122441 ✓  
116289  
119097

29  
8  
21

D2651-3  
O-Ring

Manufactured No

270 Each 1,016.0000

18 18 12/09/04

Location

Loc Qty

Loc Code

FP001  
61962  
73828  
FP-A  
78126 ✓

16  
12  
4  
1000  
1000

MS27039-1-08  
Screw

Purchased No

270 Each 1,168.0000

46 46 12/09/04

Location

Loc Qty

Loc Code

ST291  
117423  
119075  
120308  
121011  
121243  
121708 ✓

1168  
81  
1  
166  
43  
500  
377

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 6

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

270

Each

1,209.0000

44

44

Insert

## Location

## Loc Qty

## Loc Code

ST280

205

119084

116

120671

89

ST281

44

120807

36

120837

8

ST282

122474 ✓

960

121269

960

44 44 12/08/04

MS27039-4-06

Purchased

No

270

Each

114.0000

1

1

Screw

## Location

## Loc Qty

## Loc Code

ST292

114

119075 ✓

114

AN960JD10L

✗ NAS1149D0332J ✓

Purchased

No

270

Each

0.0000

46

46

Washer

121708 ✓

46 46 12/09/04

D3537-1

Manufactured

No

270

Each

124.0000

4

4

Wearpad

4 4 12/09/05

## Location

## Loc Qty

## Loc Code

FP002

124

81362

3

83254

1

83255

3

83256

20

85457

49

85458

48

88562 ✓

✗ ✗

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 7

Work Order ID: 86704

Parent Item: D206-642-241

Parent Item Name: Replacement Skidtube

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

D3537-3 Wearpad	Manufactured	No	270	Each	30.0000	1	1	12/09/04
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	30				
			78836	1				
			83327 ✓	12				
			85481	17				
D3535-13 Wearshoe	Manufactured	No	270	Each	24.0000	1	1	12/09/04
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	24				
			79850	1				
			81353	10				
			86229 ✓	13				
D3536-13 Gasket	Manufactured	No	270	Each	16.0000	1	1	12/09/04
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP002	16				
			81344 ✓	16				
D3535-21 Wearshoe	Manufactured	No	270	Each	20.0000	1	1	12/09/04
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			FP001	19				
			80329 ✓	6				
			86231	13				
			FP002	1				
			78987	1				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

July-06-12 11:37:25 AM

**Parent Item Name:** Replacement Skidtube

**Required Date:** 8/10/12

**Required Qty: 1.00**

270	Each	17.0000
-----	------	---------

1 1 12/09/04

Loc QtyLoc Code

FP

3

83433

3

FP002

14

78966 ✓

14

270	Each	19.0000
-----	------	---------

1 1 12/09/04

Loc Qty

**Loc Code**

FP001

19

70462

1

78984✓

15

82751

3

270	Each	21.0000
-----	------	---------

1 1 12/09/04

Loc Qty**Loc Code**

FP002

21

81341 ✓

12

86252

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

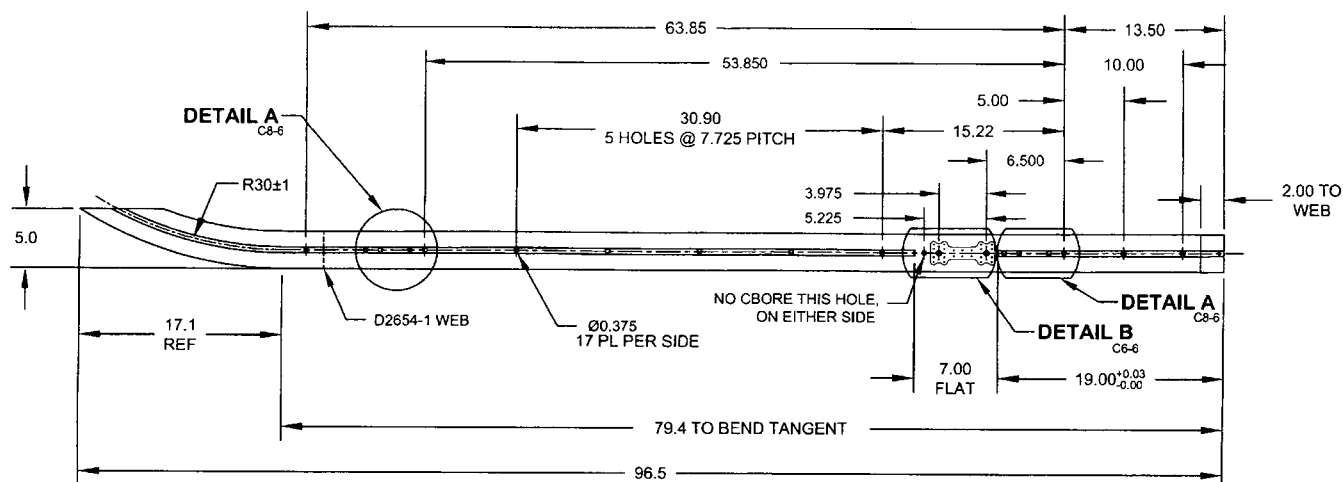
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86704  
RD1207-11

RELEASED  
08-07-23

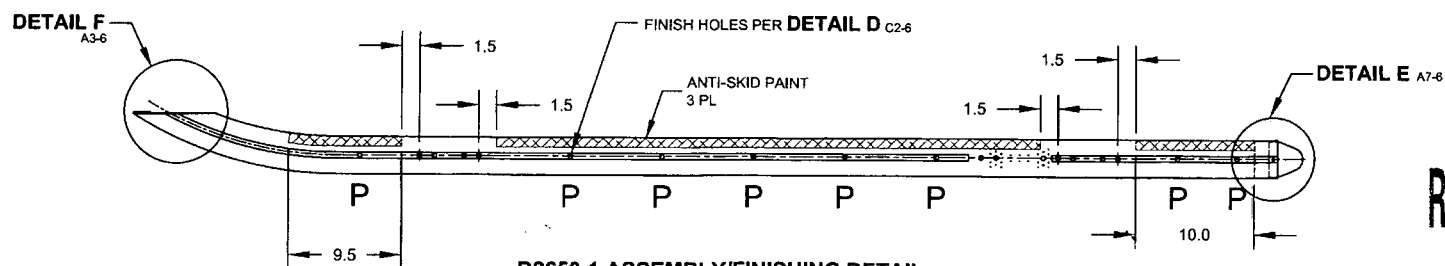
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS, SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	AJS		
CHECKED			
MFG. APPR.		DRAWING NO.	REV. F
APPROVED		D2650	SHEET 1 OF 6
DE APPR.		TITLE	SCALE
		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	






**D2650-1 BENDING/DRILLING DETAIL**



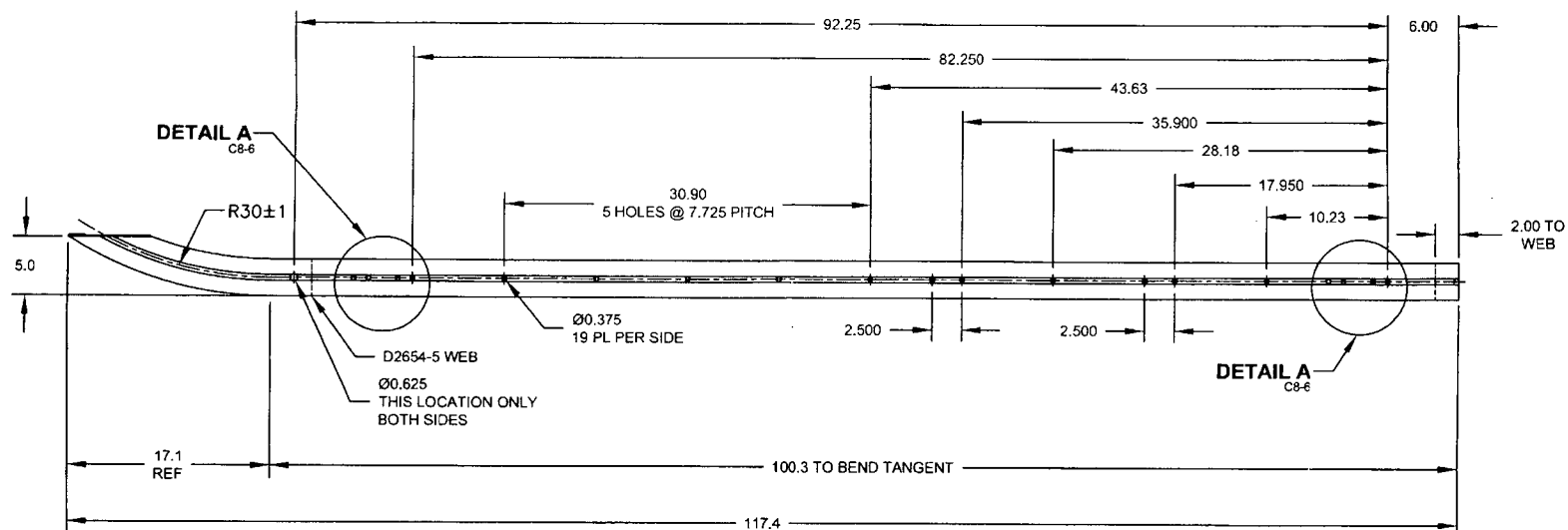
**D2650-1 ASSEMBLY/FINISHING DETAIL**

RELEASED  
880922/114

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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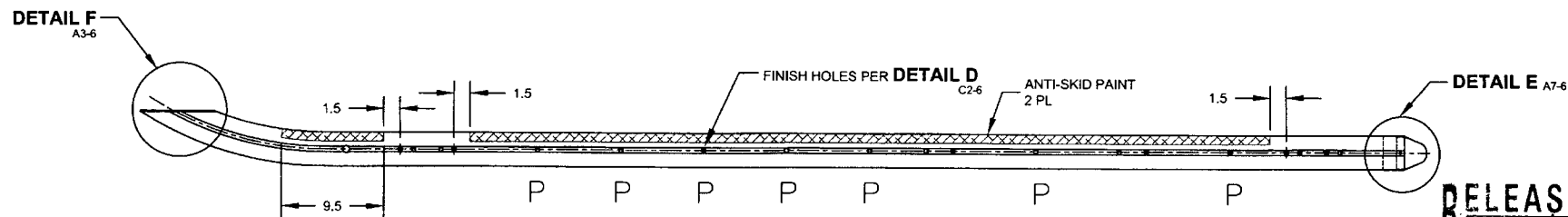









**D2650-5 BENDING/DRILLING DETAIL**

86709

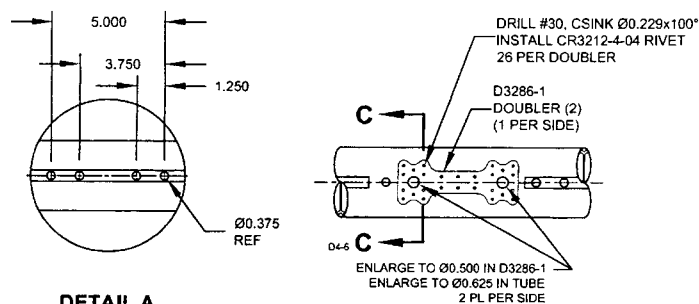


**D2650-5 ASSEMBLY/FINISHING DETAIL**

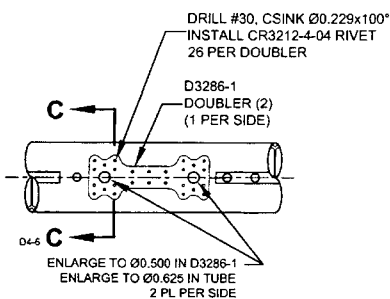
RELEASED

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC	
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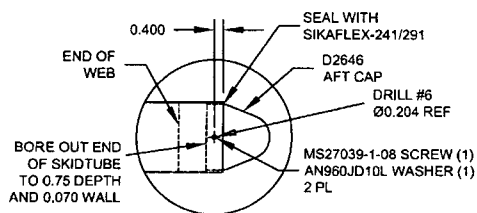




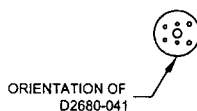
**DETAIL A** C2-2  
SCALE 2X D7-2  
C2-3  
C2-4  
D7-4  
C2-5  
D6-5



**DETAIL B** C3-2  
SCALE 2X C3-3



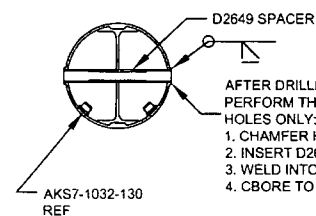
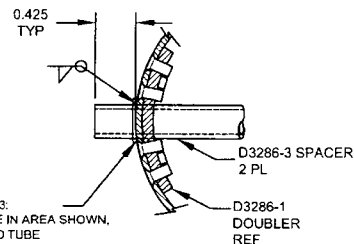
**DETAIL E** B2-2  
SCALE 2X B2-3  
B1-4  
B1-5



**DETAIL F** B8-2  
SCALE NONE B8-3  
B8-4  
B8-5

**SECTION C-C** C7-6  
SCALE NONE

- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



**DETAIL D** B4-2  
FOR Ø0.375 HOLES ONLY B4-3  
SCALE 3X B4-4  
B4-5

709

**DETAIL F NOTES:**

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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NO. 299

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: B85361  
Part #: A206-642-541  
Description: Skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum.  
Current: AC[ ☒ ] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Penetration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Incomplete Fusion:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Cracks:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Burn through:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

Qualifier David J. Javel Date of Test Coupon 12-07-26

Welder Barclay Elliott Date of Test Coupon 12-07-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld